

Date: Monday, 8/21/2006 2:11:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE, OUTBOARD, RH, 206
Job Number : 28255	
Estimate Number : 10523	
P.O. Number : <i>N/A</i>	Part Number : D26652
This Issue : 8/21/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2665 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 27671	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 9/20/2006 Qty: 12 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length

B 25347

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

1- Program batch number

2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

JL SA 06.09.01

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

JL 06/09/03

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*JL SA 06.09.01*

5.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK*En 06/09/03*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/15

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 8/21/2006 2:11:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 28255

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

a.m 06-09-05

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-09-12

(12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 06 09 12

(12)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST350*

RB 06/09/14

(12)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/09/15

(12)

Job Completion



u Dec 9.15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order: 28255
Description: 206 Saddle, Outboard, Right side	Part Number: D2665-2
Inspection Dwg: D2665 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.121	.119	.121	.121		
B	0.100	0.140		.121	.121	.121	.121		
C	1.125	1.145		1.132	1.132	1.130	1.130		
D	0.615	0.685		.675	.675	.675	.675		
E	0.240	0.260		.254	.250	.250	.251		
F	1.313	1.343		1.326	1.327	1.325	1.327		
G	0.210	0.230		.221	.220	.220	.220		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.495	2.495	2.495	2.495		
J	1.565	1.585		1.572	1.571	1.570	1.569		
K	0.235	0.240		.240	.239	.239	.238		
L	0.100	0.120		.116	.119	.119	.113		
M	0.990	1.010		1.003	1.001	1.001	1.001		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		6.000	6.000	6.001	6.001		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.500		
R	0.313	0.318		.314	/	/	/		
S	0.313	0.318		.314	/	/	/		
T	2.495	2.505		2.498	2.499	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.794	.794	.794	.794		
W	0.540	0.560		.547	.550	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	/	/	/		
Z	0.912	0.932		.920	.921	.922	.922		
AA	0.490	0.510		.497	.500	.499	.499		
AB									
AC									
AD									
AE									
AF									
AG									
AH									

Accept/Reject

Measured by: SD	Audited by: E
Date: 06/09/02	Date: 06/09/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 28255
Description: 206 Saddle, Outboard, Right side	Part Number: D2665-2
Inspection Dwg: D2665 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.116	.115	.118	.119		
B	0.100	0.140		.119	.120	.118	.115		
C	1.125	1.145		1.131	1.130	1.134	1.134		
D	0.615	0.685		.675	.675	.675	.675		
E	0.240	0.260		.250	.249	.248	.249		
F	1.313	1.343		1.321	1.325	1.323	1.324		
G	0.210	0.230		.216	.215	.218	.219		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.495	2.495	2.495	2.495		
J	1.565	1.585		1.570	1.568	1.573	1.572		
K	0.235	0.240		.238	.238	.239	.238		
L	0.100	0.120		.114	.113	.114	.114		
M	0.990	1.010		1.001	1.000	1.001	1.000		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		6.001	5.999	5.999	5.999		
P	1.245	1.255		1.250	1.249	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.499	2.500		
R	0.313	0.318		/	/	/	/		
S	0.313	0.318		/	/	/	/		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.798	.797	.797		
W	0.540	0.560		.550	.550	.550	.550		
X	1.674	1.684		1.679	1.678	1.678	1.679		
Y	0.257	0.262		/	/	/	/		
Z	0.912	0.932		.922	.922	.922	.921		
AA	0.490	0.510							
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L	Audited by: En
Date: 06/09/02	Date: 06/02/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order: 28255
Description: 206 Saddle, Outboard, Right side	Part Number: D2665-2
Inspection Dwg: D2665 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. C and record below:

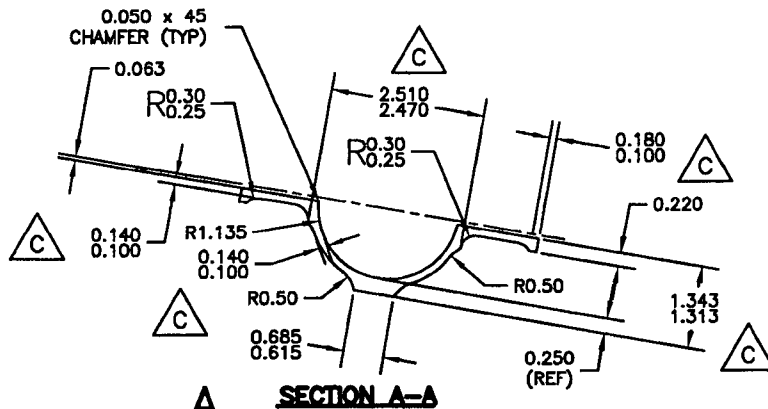
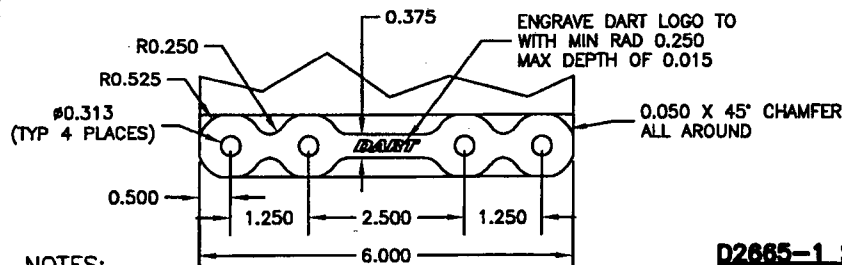
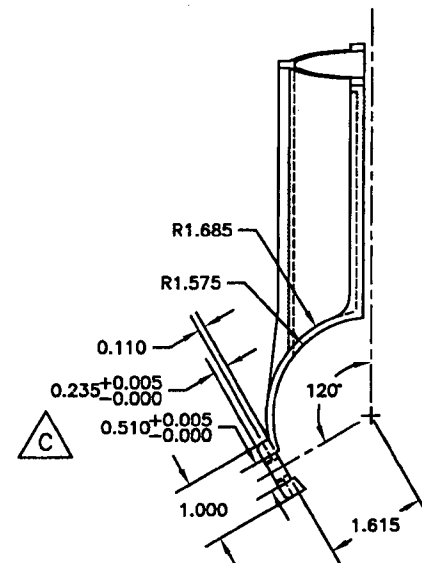
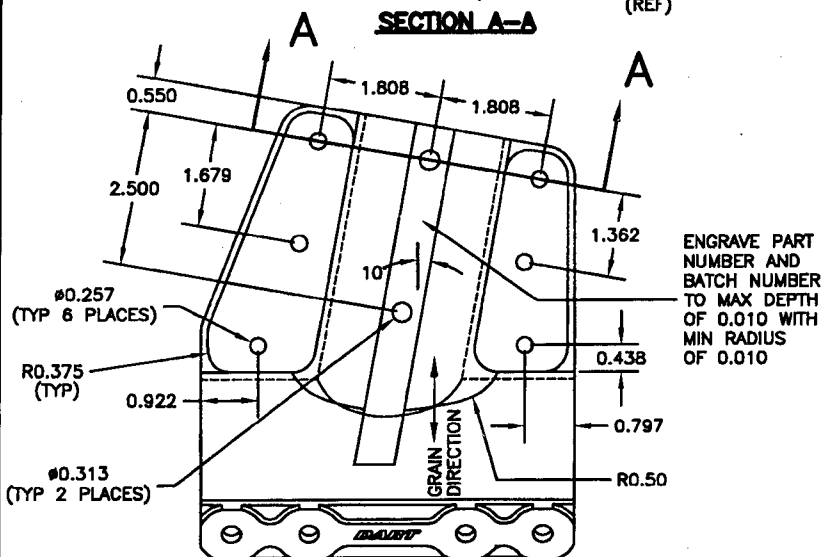
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.118	.120	.118	.120		
B	0.100	0.140		.119	.117	.117	.117		
C	1.125	1.145		1.136	1.139	1.136	1.139		
D	0.615	0.685		.675	.675	.675	.675		
E	0.240	0.260		.247	.248	.249	.249		
F	1.313	1.343		1.324	1.326	1.326	1.327		
G	0.210	0.230		.218	.220	.219	.220		
H	0.100	0.180		.140	.140	.140	.140		
I	2.470	2.510		2.495	2.495	2.495	2.495		
J	1.565	1.585		1.575	1.577	1.575	1.578		
K	0.235	0.240		.239	.238	.239	.239		
L	0.100	0.120		.117	.115	.117	.117		
M	0.990	1.010		1.000	1.000	1.001	1.000		
N	0.510	0.515		.514	.514	.514	.514		
O	5.990	6.010		5.998	5.998	5.998	5.997		
P	1.245	1.255		1.249	1.250	1.250	1.250		
Q	2.495	2.505		2.499	2.500	2.500	2.500		
R	0.313	0.318		/	/	/	/		
S	0.313	0.318		/	/	/	/		
T	2.495	2.505		2.500	2.499	2.500	2.501		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.796	.797	.797		
W	0.540	0.560		.550	.550	.548	.549		
X	1.674	1.684		1.679	1.679	1.679	1.678		
Y	0.257	0.262		/	/	/	/		
Z	0.912	0.932		.922	.921	.922	.922		
AA	0.490	0.510							
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: J.L.	Audited by: E.D.
Date: 06/09/02	Date: 06/02/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	

DART

DESIGN <i>[Signature]</i>	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2665	REV. C SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE FWD OUTSIDE HIGH	SCALE 1:3
A	97.03.25	NEW ISSUE	
B	97.07.11	ANGLE AND NOTES ADDED	
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095	

**RELEASED**
6.6.28**NOTES:**

- 1) MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC M7075T73B)
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3.5.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES

D2665-1 SADDLE FWD OUTSIDE HIGH

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 28255

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